

Date: Monday, 22/12/2008 3:05:56 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	PIN ASSEMBLY
<b>Job Number</b> :	44244		
<b>Estimate Number</b> :	11341		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3332043
<b>This Issue</b> :	22/12/2008	<b>Drawing Number</b> :	D3332 REV. A1
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	A1
<b>Previous Run</b> :	37059	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	20/01/2009
<b>Checked &amp; Approved By</b> :	JLD 08.12.23	<b>Qty:</b>	6 Um: Each
<b>Comment</b> :	Est: A 05.01.13 New issue KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1018R0500	1018-1025 round bar .500
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**Comment:** Qty.: 0.1749 f(s)/Unit Total: 1.0496 f(s)  
 1018-1025 Steel Bar  
 Material: AISI 1018-1025 Ø0.500" Round Bar  
 (M1018-R0.500)  
 Identify for D3332-7  
 Batch: M106996

08/12/27

6 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL  
 Machine D3332-7 as per Folio FA493 and Dwg D3332

6 pcs

08/12/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

08/12/27

6 pcs

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JL 08/12/28

5.0	M1018R0313	1018-1025 round bar .313
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**Comment:** Qty.: 0.2836 f(s)/Unit Total: 1.7016 f(s)  
 1018-1025 Steel Bar  
 Material: AISI 1018-1025 Ø0.313" Round Bar  
 (M1018-R0.313)  
 Identify as D3332-9  
 Batch: M107436

09.01.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/12/2008 3:05:56 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 44244

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(x6)

Comment: LARGE FABRICATION RESOURCE 1  
Fabricate D3332-9 as per Dwg D3332

*pl09-01-12*

7.0

D33321

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Handle Assembly

Pick:

Qty Part Number Description Batch

1 D3332-1 Handle

A/R N/A Steel Rod

Identify as D3332-043

*344400 ✓*  
*M105138*

*pl09-01-13*

(x6)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Assemble and Weld using D3332-041T1 as per Dwg D3332

*pl09-01-13*

(x6)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 02/01/13*

(x6)

10.0

QC5

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*S 02/01/13*

(x6)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Cover thread only for D3332-9 prior to painting

START TIME:

*2:30*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*3:00*

*FL 09/01/19*

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/12/2008 3:05:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 44244

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

A.M 09.01.20 (2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST483

SS 09/01/21 (X6)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



mf 09-01-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

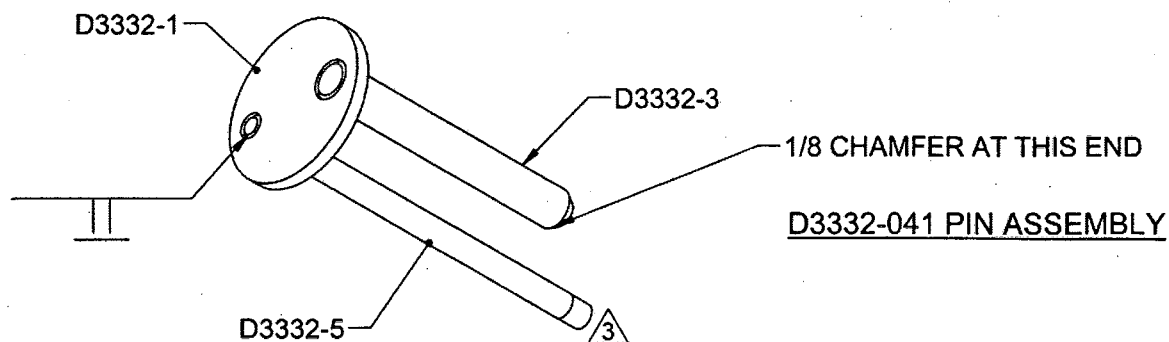
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



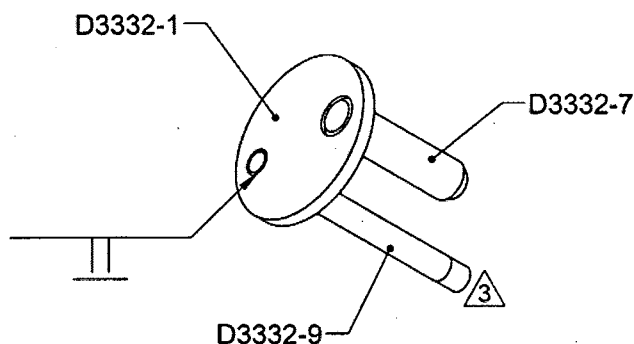


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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE $\pm 0.000$ $\pm 0.005$	



D3332-041 PIN ASSEMBLY

RELEASED  
*[Signature]*  
05/02/09



D3332-043 PIN ASSEMBLY

**NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3  
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

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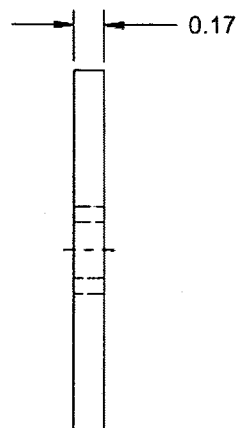
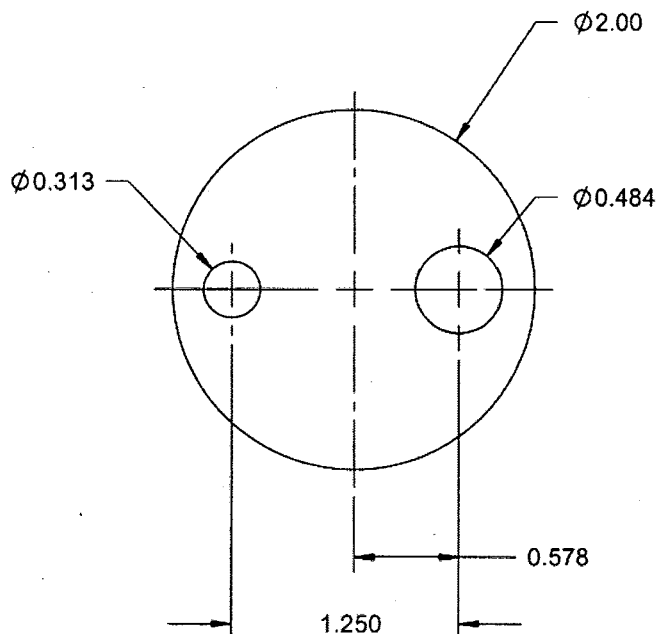
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



RELEASED  
*[Signature]*  
05/04/09

### D3332-1 HANDLE

#### NOTES:

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

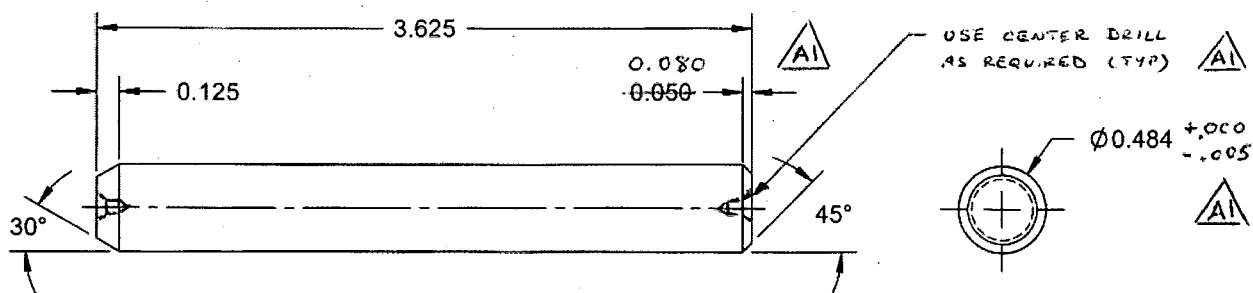
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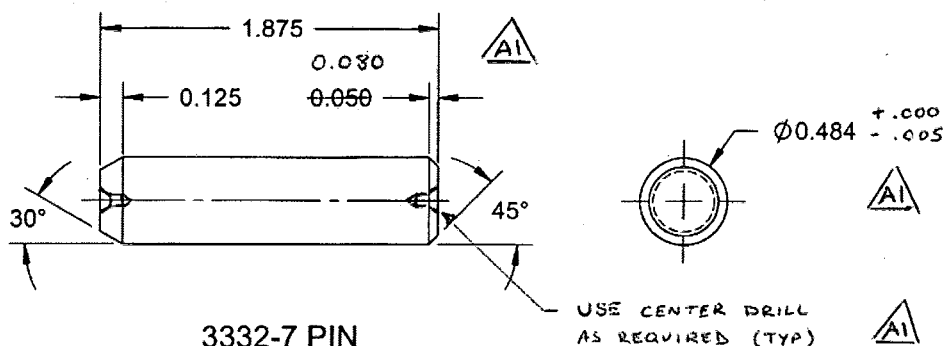
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1

**3332-3 PIN**

**RELEASED**  
*[Signature]*  
05/02/09

**3332-7 PIN****NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

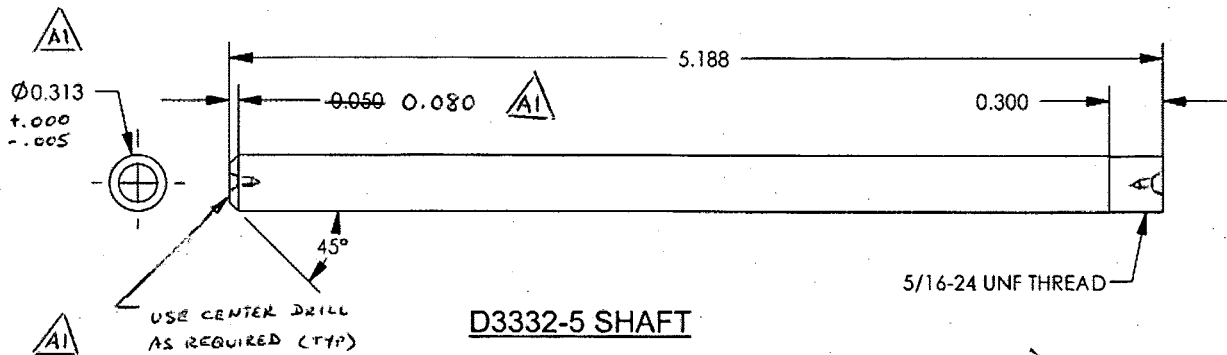
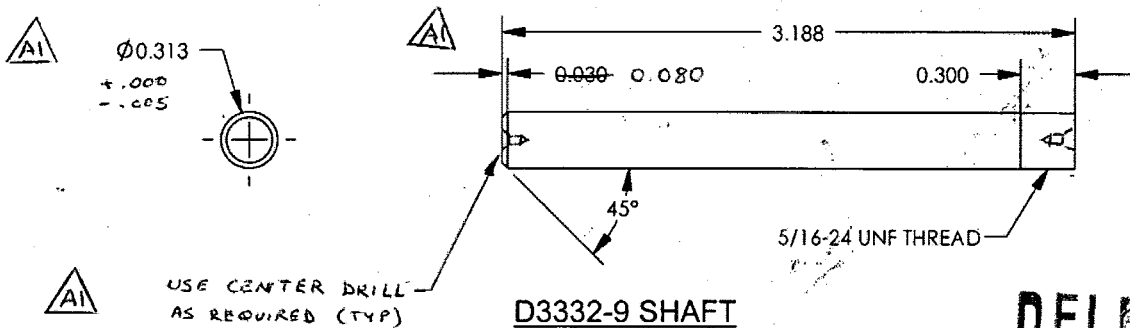
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DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:1

**D3332-5 SHAFT****D3332-9 SHAFT**

**RELEASED**  
*AB*  
09/02/09

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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